

Work Order ID 66472

Tuesday, February 15, 2011 11:45:23 AM



Page 1

Item ID:	D4017-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Short Basket Base Assembly (350)					
Start Date:	2/16/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/23/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>11-02-15</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4017	C

100	Weld per dwg A/R S.S. rod Batch: <u>M114649</u>	0.00							
	Large Fab								
Large Fab	Memo	0.00							

1- assemble ribs , weld as per dwg D4017 using DT9610B
 inspect before welding mesh
 2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary
 and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D4017
 take lid to locate hinge and bracket

11-02-28 (1x)

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

11-03-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4017-041

Accept

Revision ID:

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Start Date: 2/16/2011 Start Qty: 1.00

Required Date: 2/23/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Item ID: D4017-041

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Setup Start



Revision ID:

Item Name: Short Basket Base Assembly (350)

Stop



Start Date: 2/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

EB 11/03/02 *(Signature)*

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 w/03/02

(Signature)

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

GA
w/o
66469

EB 11/03/02 *(Signature)*

W/O:		WORK ORDER CHANGES					
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Revision ID:

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Cust Item ID:

Required Date: 2/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

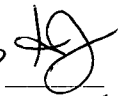


QC

Memo

0.00

Quality Control

11/03/03 
CMF

11-03-03

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Picklist Print

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Work Order ID: 66472

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)




Start Date: 2/16/2011

Required Date: 2/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4018-1  Rib		Manufactured	No			100	Each	2.0000	1	1			
<div> <div>Location</div> <div>WA</div> <div>65915</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
(same as D4017-1) ✱ D4017-3  Rib		Manufactured	No			100	Each	1.0000	1	1			
<div> <div>Location</div> <div>WA</div> <div>65905</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
✓ D4017-5  Hinge Rib		Manufactured	No			100	Each	1.0000	1	1			
<div> <div>Location</div> <div>WA</div> <div>65914</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													



B66557 (1x) 11-02-23



11-02-23

(1x) 66475



B66476 (1x) 11-02-23

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 66472

Parent Item: D4017-041



Parent Item Name: Short Basket Base Assembly (350)

Start Date: 2/16/2011

Required Date: 2/23/2011


Start Qty: 1.00

Required Qty: 1.00



✓ D4017-7 Manufactured No 100 Each 4.0000 1 1

 Rib  B66091 (1x) 11-02-23

Location	Loc Qty	Loc Code
WA	4	
58929	2	
65850	2	



✓ D4017-9 Manufactured No 100 Each 6.0000 2 2

 Rib  11-02-23

Location	Loc Qty	Loc Code
WA	6	
65911	6	

✓ D3916-041 Manufactured No 100 Each 2.0000 2 2

 Rib Assembly  11-02-23

Location	Loc Qty	Loc Code
WA	2	
65921	2	

✓ D3916-5 Manufactured No 100 Each 10.0000 1 1

 Light Rib  11-02-23

Location	Loc Qty	Loc Code
WA	10	
57023	1	
65429	9	

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 66472

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 2/16/2011

Required Date: 2/23/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4034-041 Manufactured No 100 Each 2.0000 1 1
Aft Upper Rib Assembly
B66536 (1x) 11-02-23

✓ D4034-043 Manufactured No 100 Each 3.0000 1 1
Fwd Upper Rib Assembly
11-02-23

✓ D2581 Manufactured No 100 Each 30.0000 2 2
Mounting Bracket
11-02-23

✓ D3913-15 Manufactured No 100 Each 7.0000 1 1
Wide Handle Plate
11-02-23

Location Loc Qty Loc Code

WA 2
65785 2

Location Loc Qty Loc Code

WA 3
66094 3

Location Loc Qty Loc Code

WA 30
64112 7
65950 23

Location Loc Qty Loc Code

WA 7
64900 1
65851 6

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Page 4

Work Order ID: 66472

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 2/16/2011

Required Date: 2/23/2011

Start Qty: 1.00


Required Qty: 1.00

✓ D4016-1 Manufactured No 100 Each 7.0000 3 3

 Hinge Half, Base

Location Loc Qty Loc Code

WA 7
 65374 1
 65849 6


 B66334 (3x) 11.02.23

✓ D4020-3 Manufactured No 100 Each 1.0000 1 1

 Mesh (350 Basket Short, Base)

Location Loc Qty Loc Code

WA 1
 65907 1


 B66112 (1x) 11.02.23

✓ D4020-11 Manufactured No 100 Each 8.0000 2 2

 End Mesh, Basket

Location Loc Qty Loc Code

WA 8
 59413 1
 61306 1
 65933 6


 11.02.23

D2931 Manufactured No 150 Each 724.0000 2 2

 Bumper

Location Loc Qty Loc Code

ST504 724
 46064 724

 2 2
 11/03/02
 2

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Page 4

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Work Order ID: 66472

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 2/16/2011

Required Date: 2/23/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4021-1 Manufactured No

100

Each

16.0000

3

3



Handle Plate



B66196 (2x) 11.02.23

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA

11

65848

11

D4021-5

Manufactured No

150

Each

12.0000

2



Blanking Plate



(1x)

11/03/02

Location

Loc Qty

Loc Code

ST110

8

65675

8

ST112

4

64243

4

2

AN3-10A

Purchased No

150

Each

92.0000

6



Bolt



11/03/02

Location

Loc Qty

Loc Code

ST351

92

116075

2

116400

82

17566

8

6

AN960JD8

NAS1149DN832J Purchased

No

150

Each

10.0000

2



Washer



40 M116857 (2x)

11/03/02

Location

Loc Qty

Loc Code

ST347

10

105059

10

Tuesday, February 15, 2011 11:45:16 AM

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Page 5

W/O:		WORK ORDER CHANGES					
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Work Order ID: 66472

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 2/16/2011

Required Date: 2/23/2011

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3 Purchased No
Cherry Rivets

150 Each 1,325.000 2 2



EP 5/11/03/02

Location

Loc Qty

Loc Code

ST321

1325

107939

754

111636

571

2

MS21042L3 Purchased No
Nut

150 Each 2,820.000 6 6



EP 5/11/03/02

Location

Loc Qty

Loc Code

ST300

2820

107643

16

110844

32

111274

16

114784

9

115835

247

116391

900

116540

800

116549

800

6

NAS1149F0332P Purchased No
WASHER

150 Each 196.0000 12 12



EP 5/11/03/02

Location

Loc Qty

Loc Code

ST275

196

18057

196

12

Tuesday, February 15, 2011 11:45:16 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

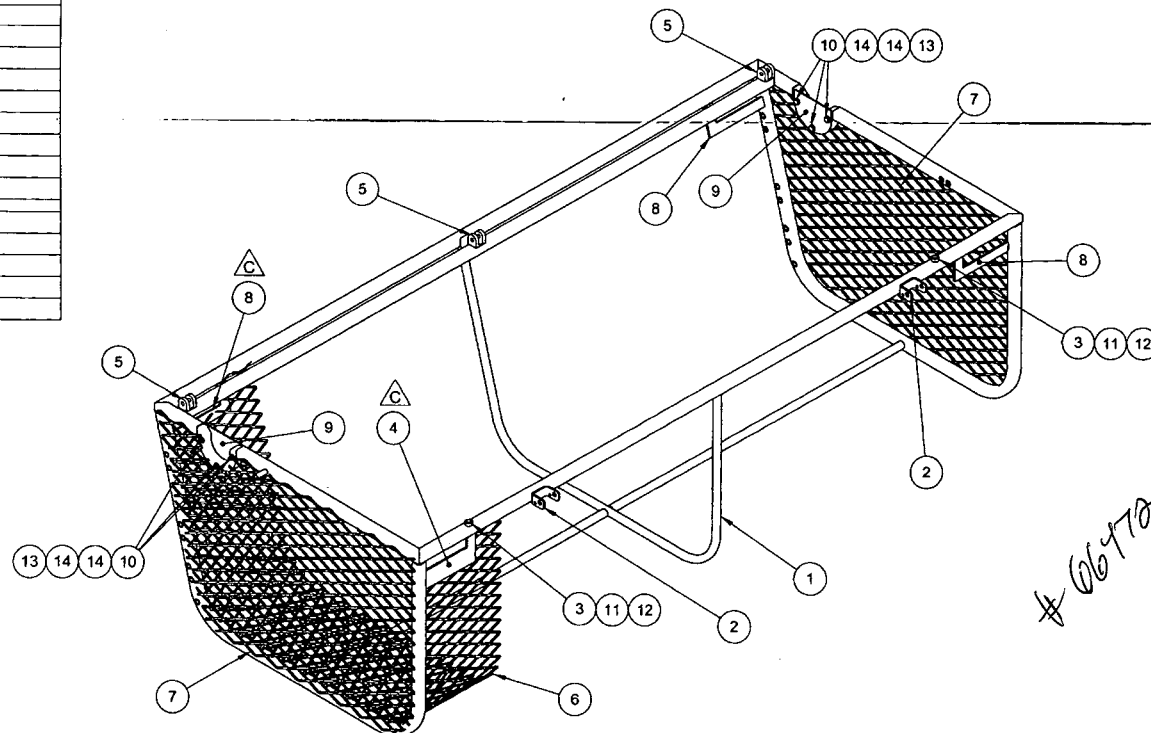
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596
RELEASED
10.06.12 P

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149F0332P; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED. DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN			
CHECKED			
MFG. APPR.	S.F.S.		
APPROVED			
DE APPR.			
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4017 TITLE SHORT BASKET BASE ASSY (350) _NTS SHEET 1 OF 5 SCALE REV. C COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

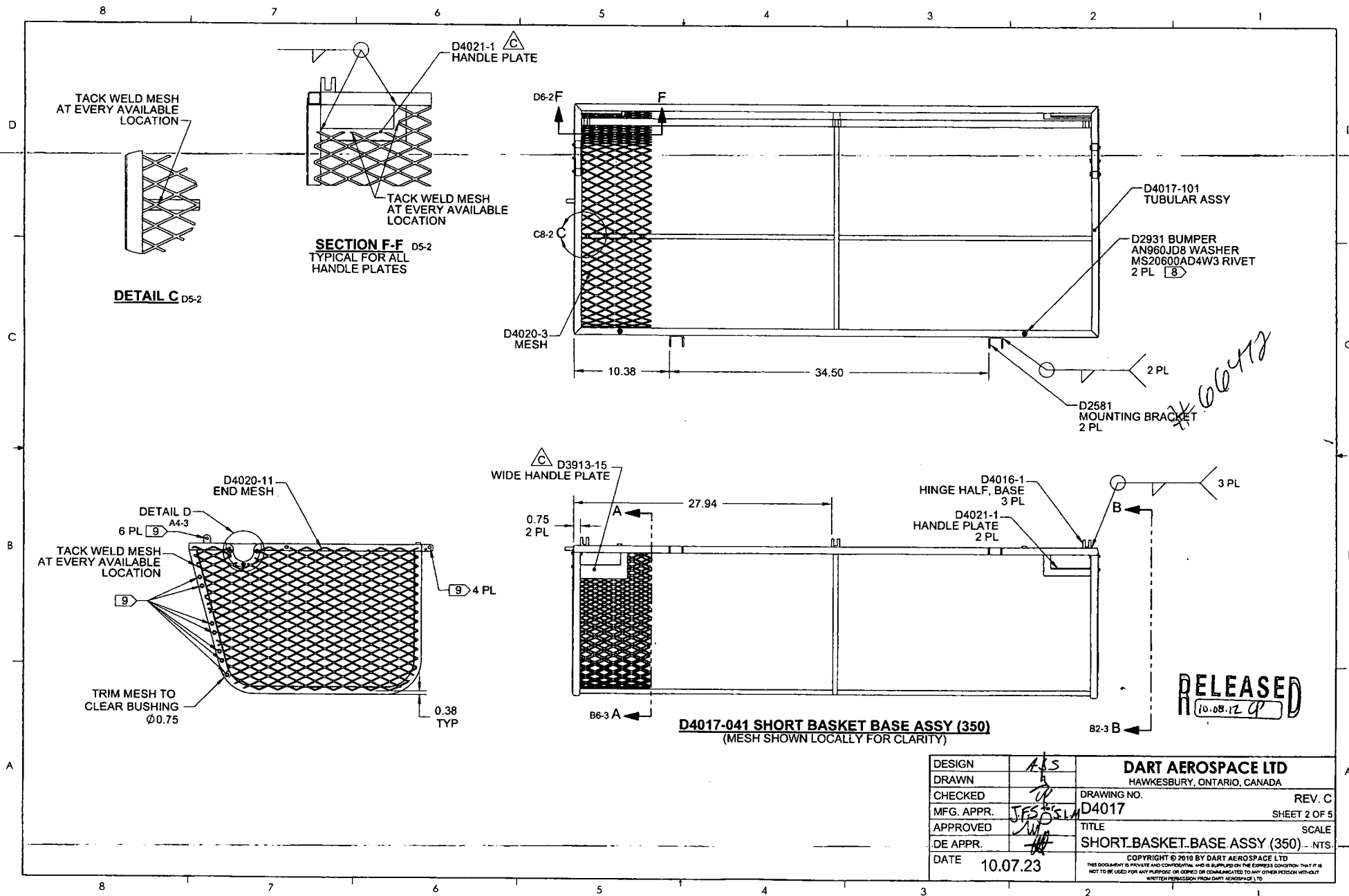
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DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D4017	SHEET 2 OF 5
MFG. APPR.	JES	TITLE	SCALE
APPROVED		SHORT BASKET BASE ASSY (350)	NTS.
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.07.23		

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

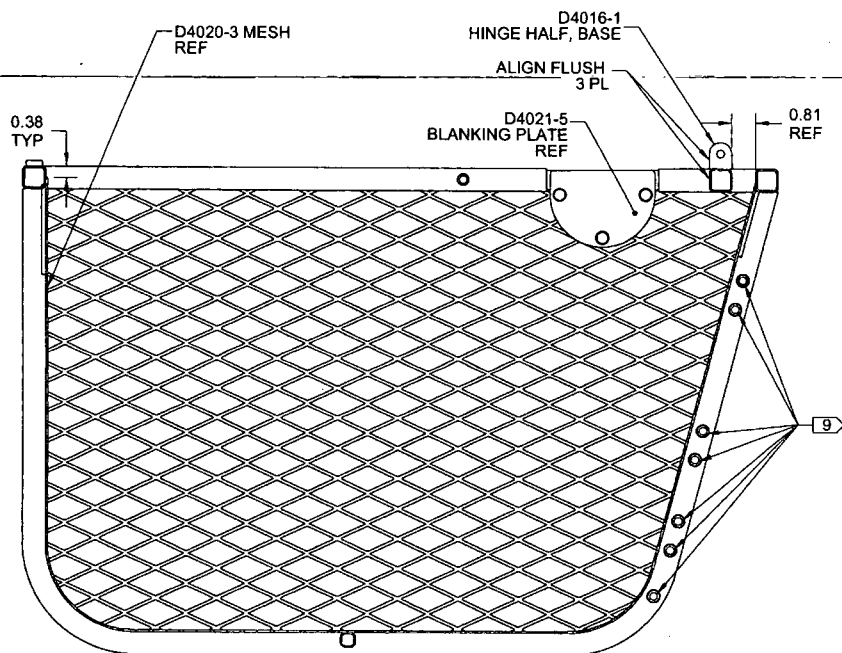
C

B

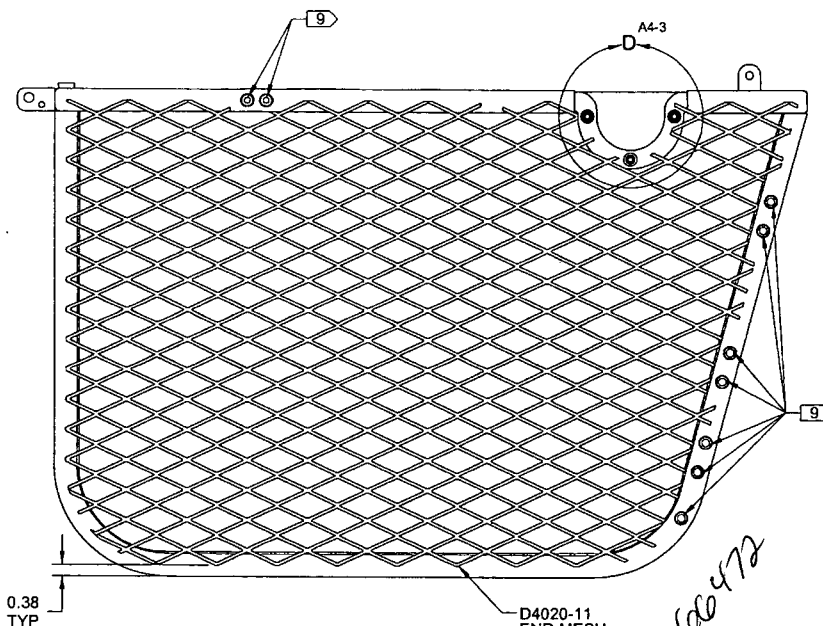
B

A

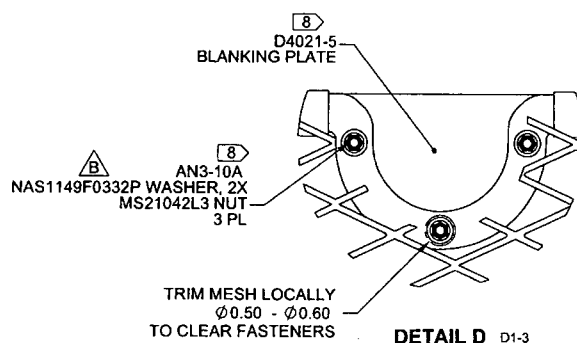
A



SECTION A-A AS-2



SECTION B-B A2-2



DETAIL D D1-3 B8-2

RELEASED
10.08.12.4

DESIGN	AKS	DART AEROSPACE LTD	
DRAWN	AKS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	TOP	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4017	SHEET 3 OF 5
APPROVED	JFS	TITLE	SCALE
DE APPR.	AKS	SHORT-BASKET-BASE ASSY (350) -NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

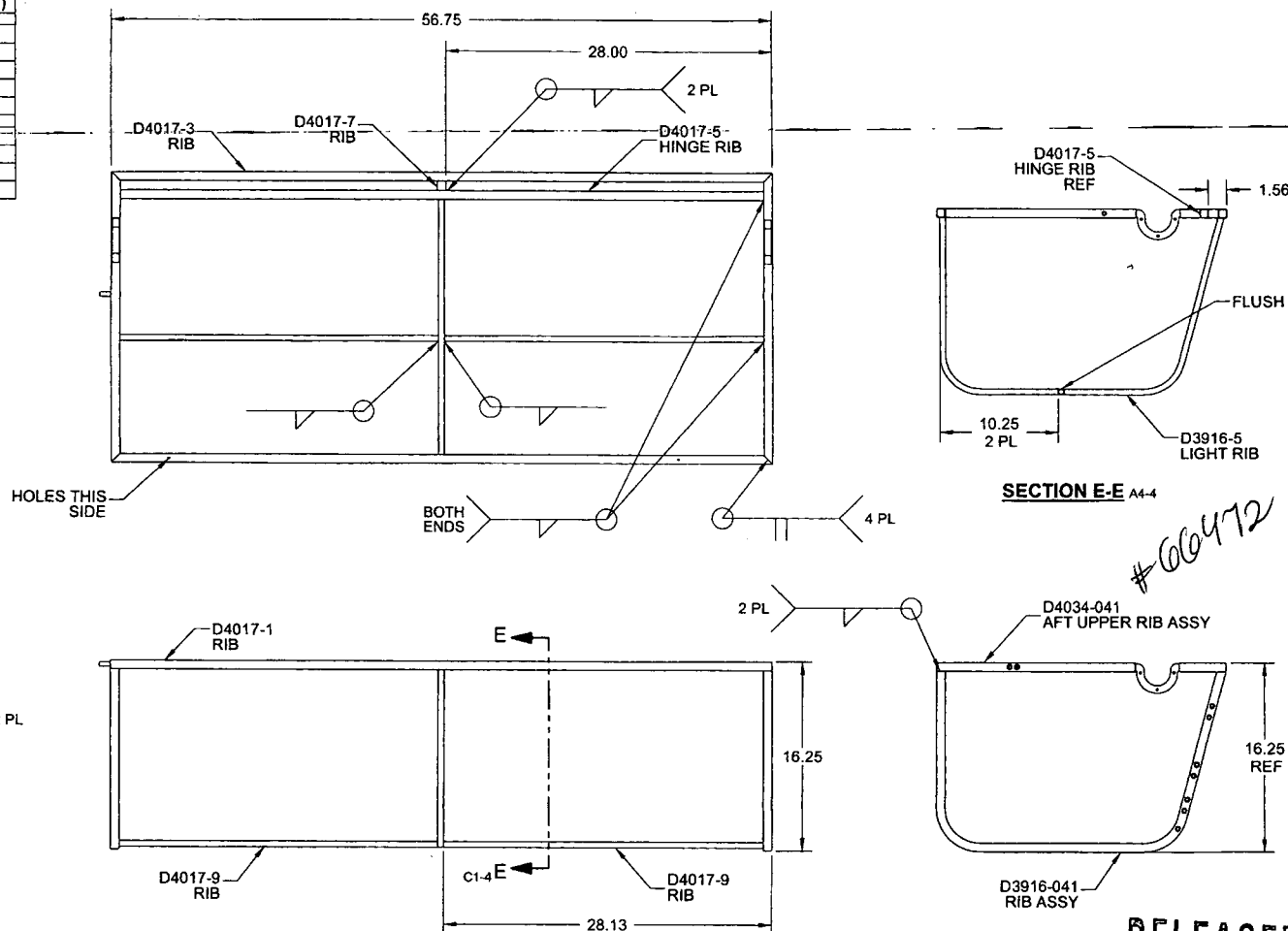
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.26 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	ALC	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	SFS	D4017	SHEET 4 OF 5
APPROVED	JW	TITLE	SCALE
DE APPR.	JW	SHORT BASKET BASE ASSY (350)	NTS
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RELEASED
10.08.23

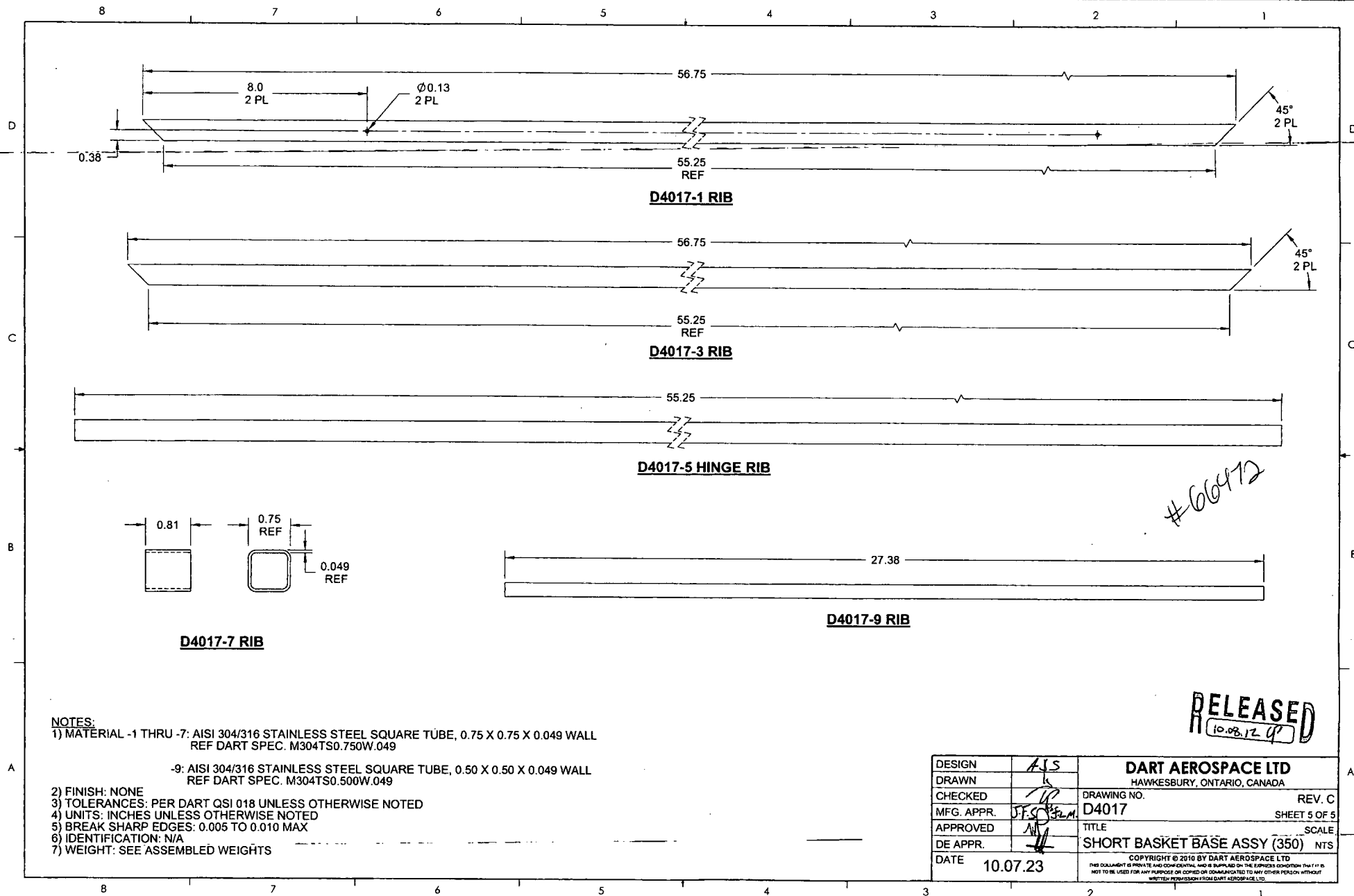
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